

Work Order ID 52599

October 2, 2009 11:28:14 AM



Page 1

Item ID:	D3414-3	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Lug					
Start Date:	02/10/2009	Start Qty:	20.00			
Required Date:	09/10/2009	Req'd Qty:	20.00			
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>09-10-2</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev B								

100		0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 2.50" x 0.500" x 2.250" long								

LF 09/20/08

20

0

110		0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3□Dwg Rev <u>B</u> Folio Rev <u>AA</u>								

H.A 09/10/10

20

0

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

H.A 09/10/10

20

0

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Item ID: D3414-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug

Start Date: 02/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 09/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

*amt 09/10/11*200

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00

*WRL DING*

Packaging

Memo

0.00

Packaging

09/10/13 (20)

150

QC21- Final Inspection - Work Order Release

0.00

*09/10/13*

QC

Memo

0.00

Quality Control

MF 09-10-13

Picklist Print

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Work Order ID: 52599



Parent Item: D3414-3RevB



Parent Item Name: Lug

Start Date: 02/10/2009

Required Date: 09/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No				f	94.1165	118.0000			

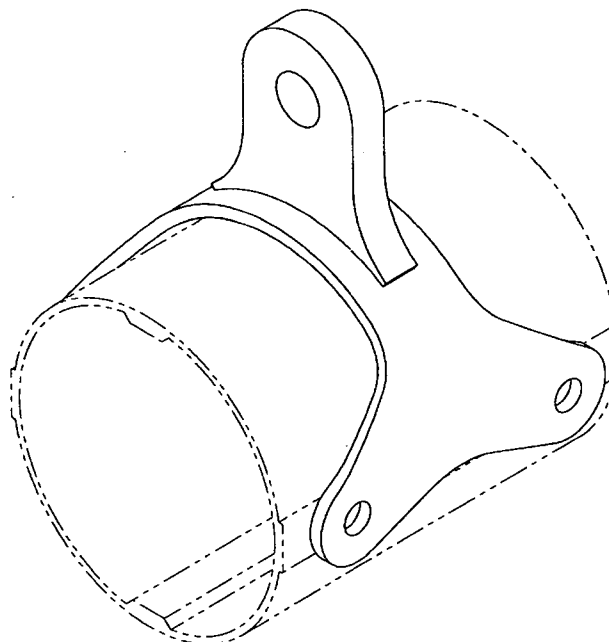
304 BAR .500 x 2.50

LT 09/10/08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	94.1165	
110966	2.9	
111330	3.16	
112320	12	
112347	9.6465	
112697	12.1	
112764	48.44	
18929	5.87	

3.75

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

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WORK ORDER

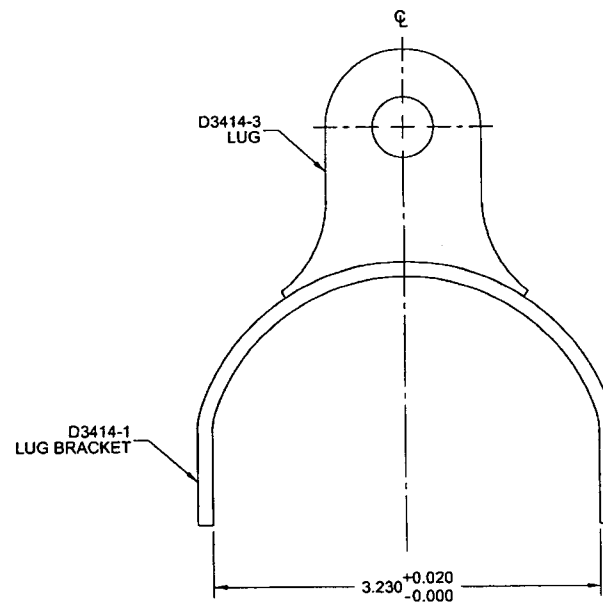
NO. 52599
per 09-10-2

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07/06/06

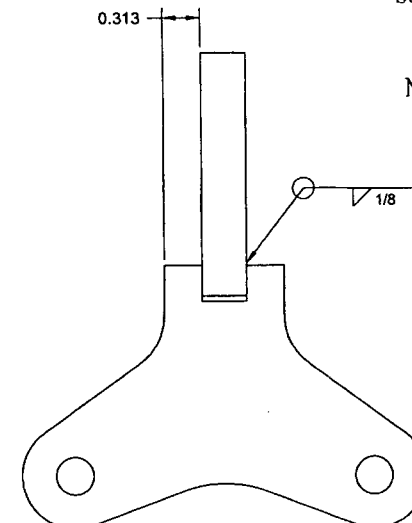
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 1 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
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D3414-041 LUG ASSEMBLY



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09/06/17

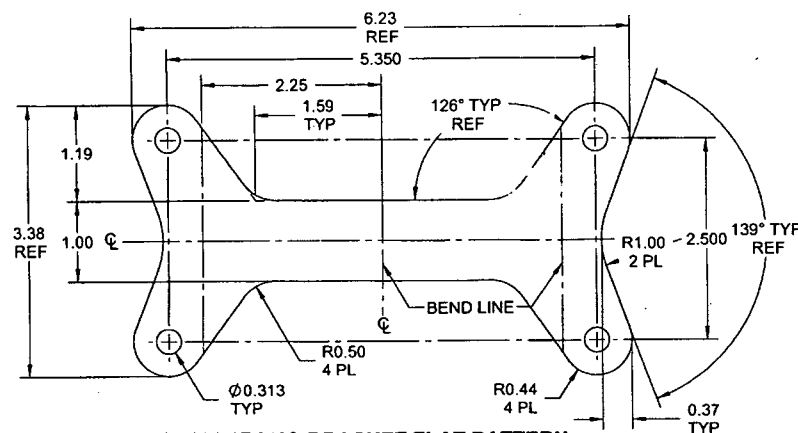
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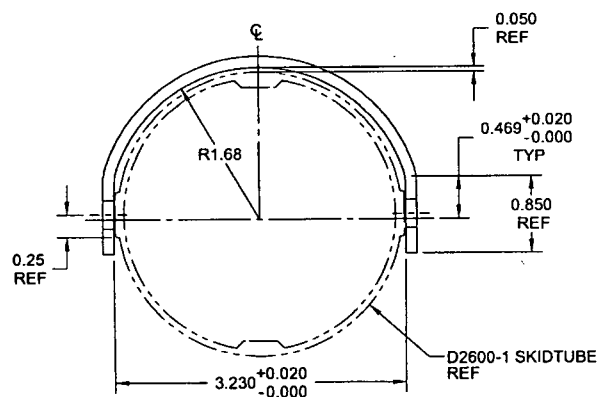
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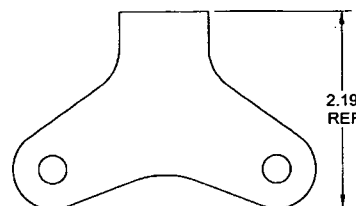
BP 09-10-2



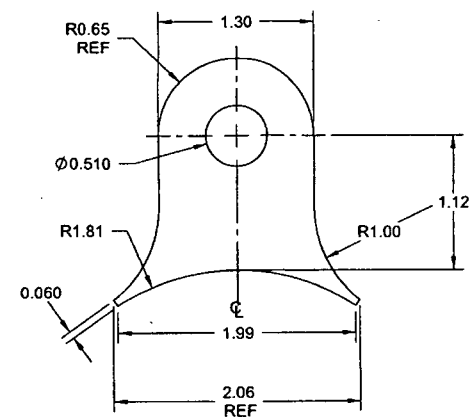
D3414-1F LUG BRACKET FLAT PATTERN



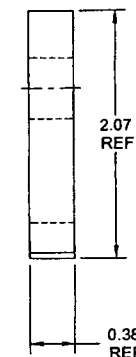
D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG



NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



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09/06/17

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DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
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APPROVED		TITLE	SCALE
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